

HH HI-HEAT™ BLACK



GENERAL INFORMATION

Hi-Heat™ Black is a superior, high temperature coating. It is a great coating for engine parts or exhaust systems on cars, trucks, motorcycles, small engines, etc., where high temperature is a concern. It features fast coverage and cures to a beautiful semi-gloss jet black finish that will endure 1400°F with no flaking or discoloration. Hi-Heat™ Black comes ready to spray and no reduction is required. Parts are dry enough to handle in one hour. No baking is required.



1. PREPARATION

For new steel surfaces make sure metal is bare and clean with no traces of water, oil, wax, or surface rust. Wiping parts with a quality, mid temperature lacquer thinner (such as House of Kolor® RU202 Lacquer Thinner) works well as a final wash. Allow to dry, then start application. If possible, warm the parts with a heat lamp. This will speed up the process.



2. SUBSTRATE

- Bare Steel



3. SANDING THE SUBSTRATE

For previously coated or rusted surfaces, sand or bead blasting is the only method of preparation recommended. After blasting, prepare surface the same as described above for new steel surfaces.

NOTE: Sand or bead blasting is the ideal surface preparation for all surfaces including new steel surfaces.

Apply Hi-Heat™ Finish as soon as possible after cleaning for maximum adhesion.



4. COMPONENTS

- Ready To Spray



5. MIXING HI-HEAT™

- Ready To Spray



6. GUN SET UP

- Conventional Gun = 45 to 55 PSI
- HVLP Gun = 10 PSI at the cap
(Refer to spray gun manufacturer's recommendations)
- Needle/Nozzle = 1.3 to 1.5
(Depending on the size of object being painted)
- Trigger Pull = 25% to 50%
- Air Brush = Not Recommended



7. APPLYING HI-HEAT™ BLACK (HH04)

Hi-Heat™ Black is ready to spray as packaged. Do not add any extra reducer. Warm parts with an infra-red heat lamp. Remove heat lamp from booth, then apply one medium wet coat. Allow 10-20 minutes dry time or until paint has flashed dull then apply one more medium wet coat. Apply just enough paint to achieve coverage, but never more than two medium coats of HH04. Many motorcyclists also coat the exhaust pipes inside to minimize bluing.

WARNING: Proper film thickness is critical for good heat resistance properties. Dry film thickness should not exceed 0.6 mils. Excessive film thickness will cause coating failure such as blistering and flaking. More is not better.



8. DRY TIME

Parts are ready to handle in one hour. Allow parts to cure for 24 hours after last coat is applied to ensure that solvent is no longer present in the coating. Final cure will be accomplished by the inherent heat of operation. This will cause the parts to emit smoke and odor upon first use. This is a chemical reaction that final cures the paint. After this, the parts will be a beautiful semi-gloss black finish.



9. CLEAN UP

Clean equipment thoroughly with thinner (check local regulations).

NOTES